W٥	rk	Or	der	ID	71284
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Monday, June 27, 2011 10:48:46 AM



Page 1

Item ID:

D3535-11

Accept

Setup Start

Stop

Start



**Revision ID:** 

Start Date:

Item Name:

Wearshoe

6/27/2011

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 



Reference:

**Approvals:** 

Process Plan: MC

Date:  $\sqrt{-06-27}$  Tooling:

Date:

Date:

Date:

Stop

Run



Sequence ID/

Operation Description

Set Up/ **Run Hours** 

SPC (Y/N):

Tool ID

Tool # Plan Accept Code Qty

Reject **Qty** 

Reject Number

Insp. Stamp

Work Center ID **Draw Nbr** 

**Revision Nbr** 

Rev B

D3535

Required Date: 8/5/2011

100

Waterjet

FLOW CNC Waterjet 304,040

FLOW WATER JET

Memo

1-Cut as per Dwg D3535 □Dwg Rev: Deburr if necessary

0.00

c 0.00 ..

R Prog Rev: R

B11-7-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

1B11-7-21

120

QC

QC8- Inspect parts - second check

Memo

Quality Control

0.00

Dart Aerospace	Ltd
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W/O:	•	WORK ORDER CHANGES												
DATE	STEP	PRO	CEDURE CH			Ву	Date	Qty Approval Chief Eng /		Approval QC Inspector				
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#### Work Order ID 71284

Monday, June 27, 2011 10:48:46 AM



Page 2

Item ID:

D3535-11

Accept



Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name: Wearshoe

Required Date: 8/5/2011

6/27/2011

**Start Qty: 12.00** Reg'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

**Date:** \_\_\_\_\_

Process Plan: Date: Tooling:

Date:

Date:

Start Run

Qty



Sequence ID/ Work Center ID

130

Brake NC

Operation Description

NC BRAKE

Memo

Memo

Set Up/

0.00

0.00

SPC (Y/N):

**Run Hours** 

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Stop

Insp. Stamp

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158Identify as D3535-11

SB 11/07/05

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

320 POFINISH TIME:

M 115128

<b>Dart Aerospace Ltd</b>	D	art	Aer	ospa	ice L	.td
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W/O:			V	ORK ORDER CHANGI	ES				,
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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### Work Order ID 71284

Monday, June 27, 2011 10:48:46 AM



Page 3

Item ID:

D3535-11

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Wearshoe Item Name:

Required Date: 8/5/2011

6/27/2011

Start Qty: 12.00

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID** 

160

Quality Control

**Operation** Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

BL 11-7-6.

170

Packaging

Packaging

Identify as per dwg & Stock Location FD. 19

Memo

0.00

B & Bl 107-6

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart	<b>Aeros</b>	pace	Ltd
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W/O:			WORK ORDER CHANGES									
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# **Picklist Print**

Monday, June 27, 2011 10:48:40 AM

Work Order ID: 71284

Parent Item:

D3535-11

Parent Item Name:

Wearshoe



Start Date: 6/27/2011

Required Date: 8/5/2011

Page 1

**Start Qty: 12.00** 

Loc Code

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	217.6630	0.7015	8.861053	9,5		
										181	1-7-4		

304/316 .040 Sheet

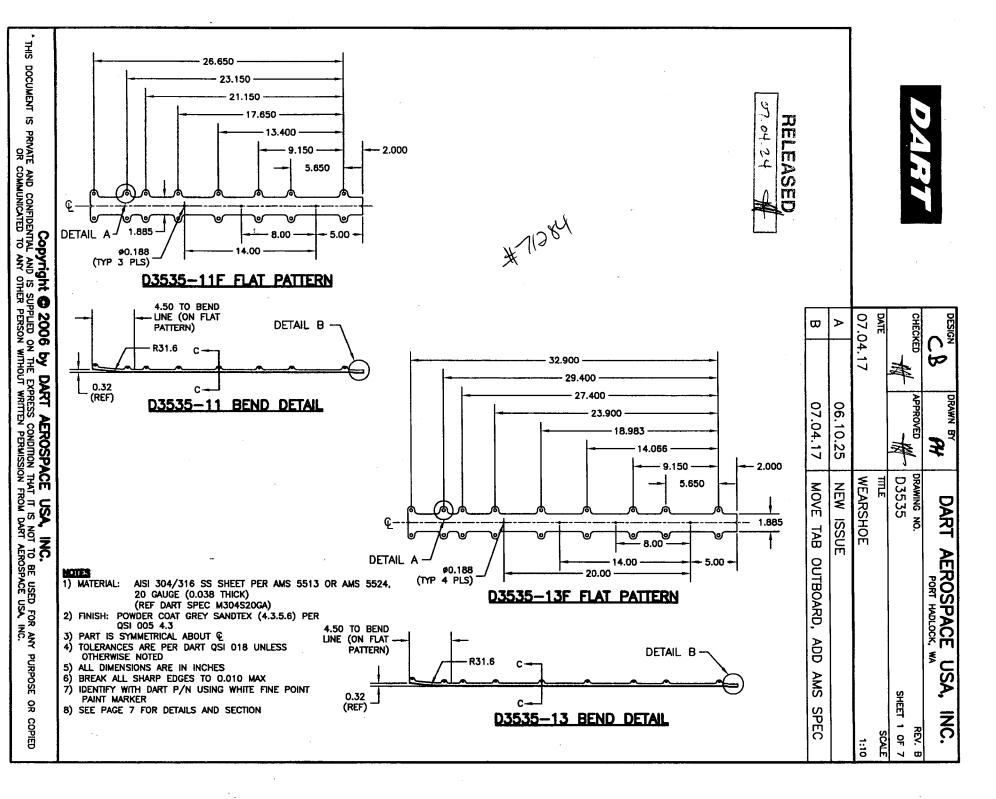
Location Loc Oty 217.663 MAT020 116623 0.2 117550 9.363 208.1 117933

117933

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

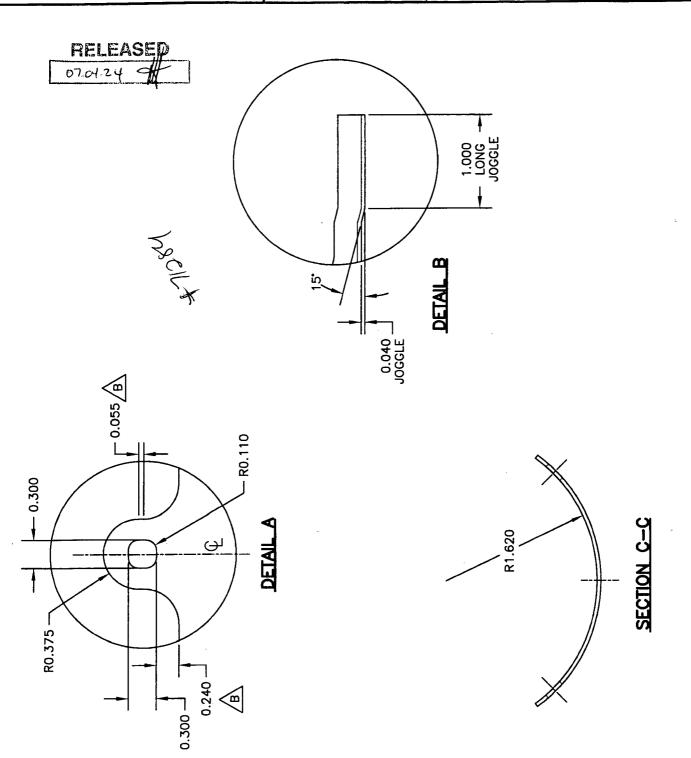


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		Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC inspector
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DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED 44	APPROVED/	DRAWING NO.	REV. 8
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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# **Dart Aerospace Ltd**

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DART AEROSPACE LTD	Work Order:	11284
Description: Wearshoe	Part Number:	D3535-11
Inspection Dwg: D3535 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.010	5,00	X		7 1801	
8.00	+/-0.010	00.8	3		7	
14.00	+/-0.010	14.00	2		7	
21.150	+/-0.010	21.156	بر		7	
26.650	+/-0.010	26.620	<u> </u>		7	
5.650	+/-0.010	5.650	<u>~</u>		7	
Ø0.188	+0.005/-0.001	118	2		V 1302	
0.300	+/-0.010	303	2		V	
0.300	+/-0.010	-3×6	<b>x</b>	·	V	
0.038	+/-0.010	.035	>		V	
				ye.	gev Tag	
				A**		

Measured by:	B	Audited by:	2	Prototype Approval:	N/A
Date:	11-7-4	Date:	1407/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/DD 41	

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W/O:			WORK ORDER CHANGES								
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